

Work Order ID 59442

Friday, June 04, 2010 10:28:20 AM



Page 1

Item ID: D3909-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Lower Attach Arm

Stop



Start Date: 6/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *H*Date: *10/04* Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3909	B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

*cut 10/06/21**12 8*

Jeaspa Bandsaw

CUT BLANK 3.455" LONG

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

MACHINE AS PER FOLIO FA872 AND DWG
FOLIO REV: *AA*
DWG REV: *B**18/06/22**12 P*

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/06/22

12 8

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

DSI
10/06/23

12 8

160



Packaging

Packaging

Identify as per dwg & Stock Location: 95

0.00

Memo

0.00

10-6-23 *10x SP*

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/06/24 JJ

Memo

0.00

CL 10/6/24

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Picklist Print

Friday, June 04, 2010 10:28:24 AM

Page 1

Work Order ID: 59442



Parent Item: D3909-3



Parent Item Name: Fwd Lower Attach Arm

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP
Rev:B chg blank size in seq 100 DD 10.02.10 verified JLM IPP Rev:C as per
dwg revB DD 10.04.20 verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ M303B0.750X1.500	Replacement Barcode	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of f	Qty on 0.0000	Qty per Kit 0.3333	Total 4.210105	Qty	Date	Status
303 BAR .750" X 1.500"													

Batch# 114968 = 4.21" and 10/06/21

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59447
Description: Fwd Lower Attach Arm	Part Number:	D3909-3
Inspection Dwg: D3909	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>SP</u>
Date:	10/06/22

Audited by: I. D. T.

Preliminary Approval:	
	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.20	New Issue	KJ	[Signature]

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NOTE: Date & initial all entries

8

7

6

5

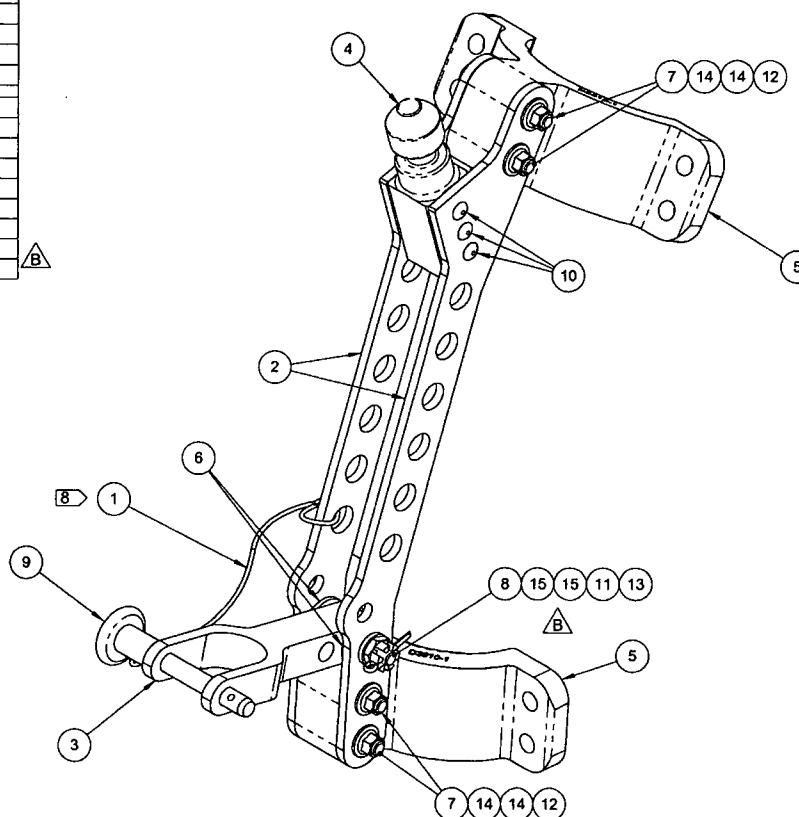
4

3

2

1

ITEM	QTY -041	P/N	DESCRIPTION
X	D3909-041		FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59442
PRO-C-04

RELEASED
2010-04-07
MP

B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED. ITEM 14 QTY 8 WAS 10. SHT 5. D3909-5 REVISED: SECTION A-A: ADDED DIM 2.68. SECTION C-C: ADDED DIM 0.250. ADDED DIM 2.68 WAS 2.38 REF 1.50 WAS 1.00. 0.250 WAS 0.220. R0.05 WAS R0.05. WEIGHT REVISED.			JPH	10.04.06	
A	NEW ISSUE			JPH	10.03.04	
REV.	DESCRIPTION			BY	DATE	
DESIGN	JPH	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA			REV. B	
DRAWN	JPH				DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>				D3909	SHEET 1 OF 5
MFG. APPR.	<i>[Signature]</i>				TITLE	SCALE
APPROVED	<i>[Signature]</i>	FWD X-TUBE LUG ASSY			NTS	
DE APPR.	<i>[Signature]</i>					
DATE	10.04.06					

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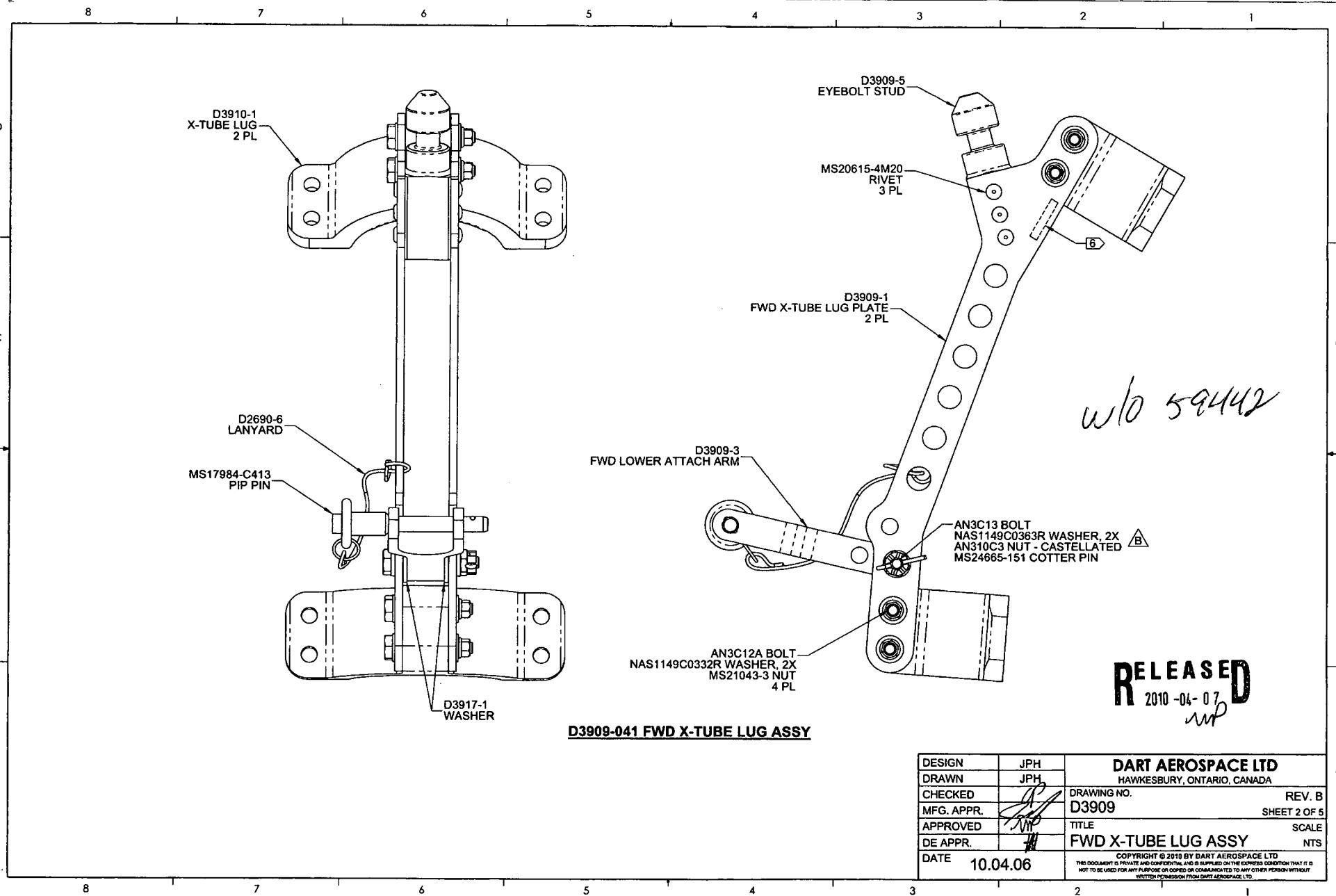
W/O:		WORK ORDER CHANGES					
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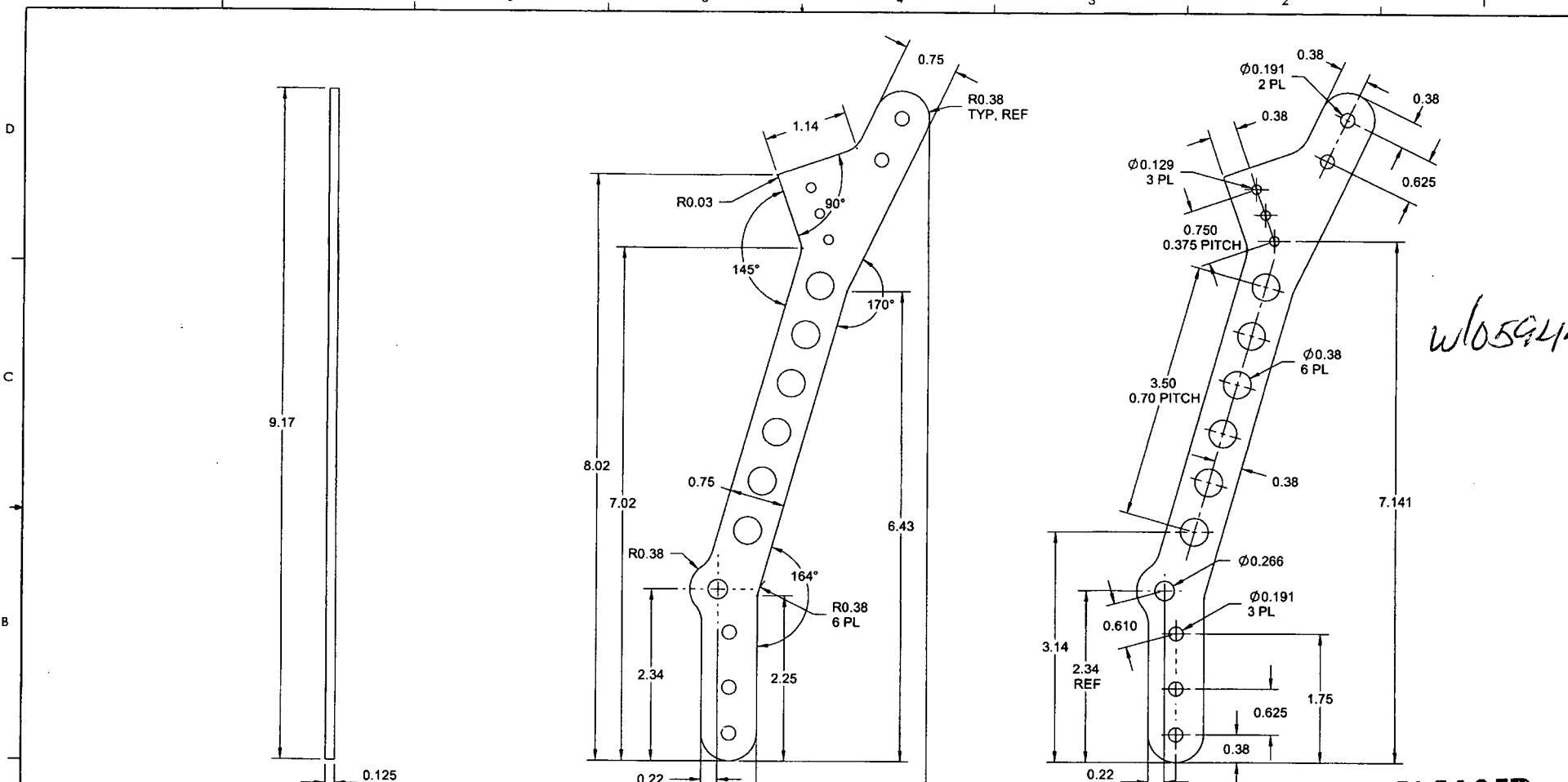
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D3909-1 FWD X-TUBE LUG PLATE

(SUPPLEMENTAL VIEW)

RELEASED
R 2010-04-07
MW

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

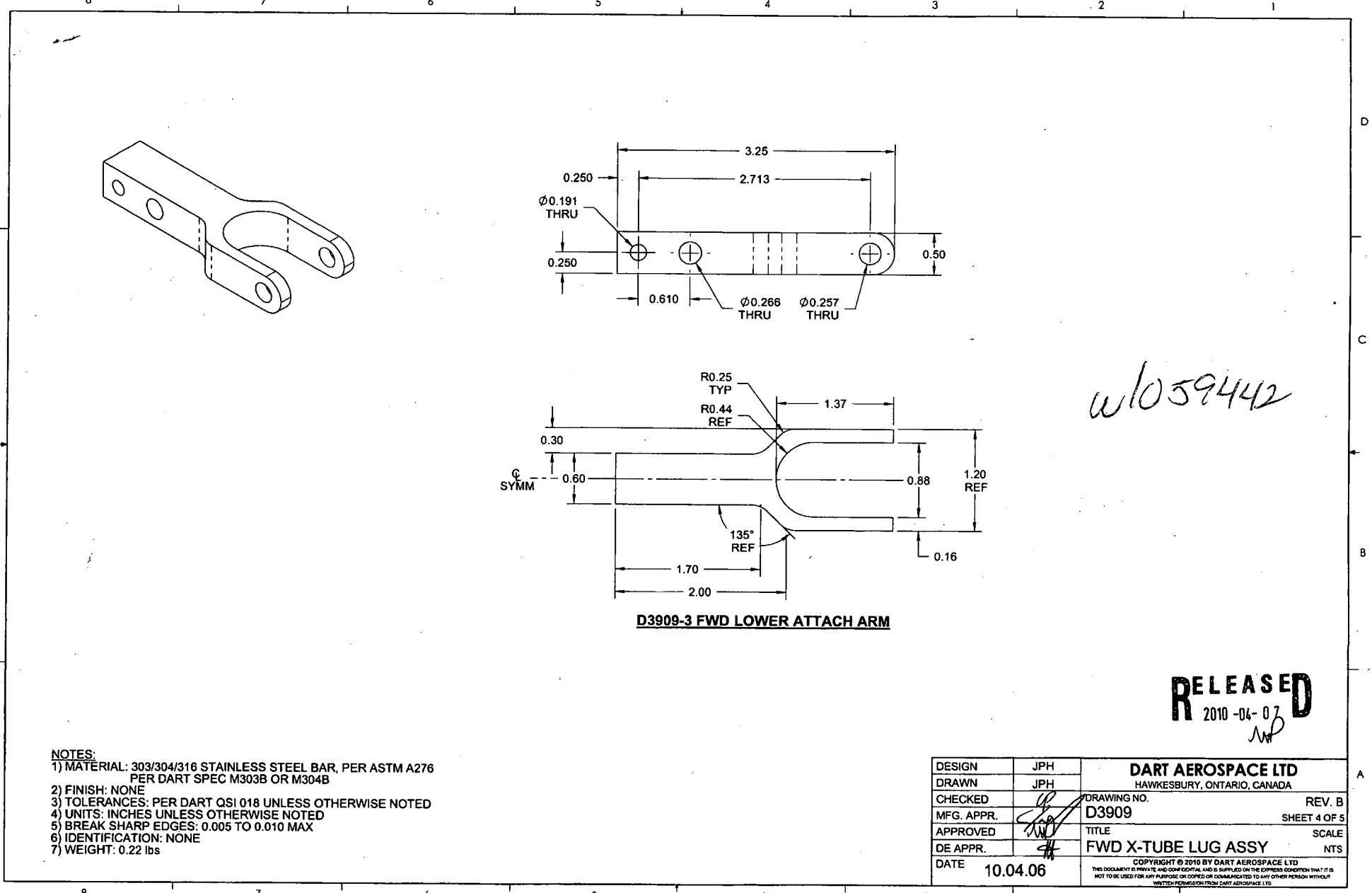
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D3909	REV. B
APPROVED	<i>[Signature]</i>	SHEET 3 OF 5	TITLE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	SCALE NTS
DATE	10.04.06	COPRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

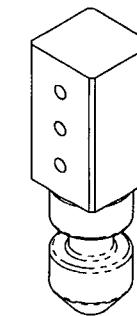
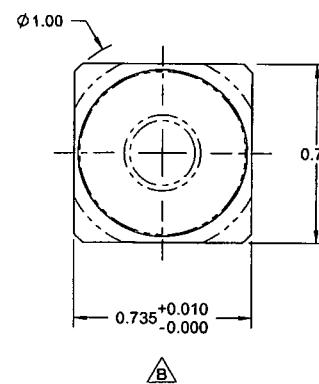
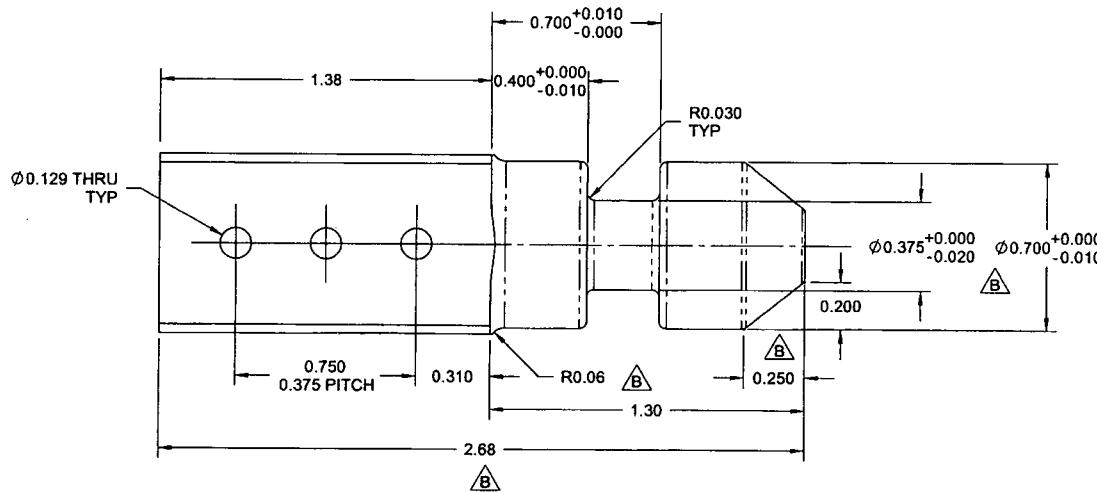
C

B

B

A

A



w1059442

D3909-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3909
MFG. APPR.		REV. B SHEET 5 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY
DE APPR.		SCALE NTS
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8 7 6 5 4 3 2 1

RELEASED
2010-04-07

JP

A

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